

Work Order ID 65465

January 18, 2011 10:30:14 AM



Page 1

Item ID:	D3475-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Dump Outlet					
Start Date:	1/18/11	Start Qty: 1.00		Cust Item ID:		
Required Date:	1/31/11	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>C2</u>	Date: <u>11/01/18</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3475	Rev C								

100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D3479 2-Spot Weld as per Dwg D3475 and Dart QSI 018								

110	QC11- Inspect spot weld per QSI004	0.00							
QC	Memo	0.00							
Quality Control									

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

3x

7 m. d 11/01/31

SB 11/01/31

3

SB 11/01/31

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65465

January 18, 2011 10:30:14 AM



Page 2

Item ID: D3475-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Dump Outlet

Start Date: 1/18/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: S9

0.00



Packaging

Memo

0.00

Packaging

1/1/31328

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/0211-02-1
(3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 18, 2011 10:30:13 AM

Page 1

Work Order ID: 65465

Parent Item: D3475-041

Parent Item Name: Dump Outlet



Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A New Issue 06-02-03 JLM
IPP Rev: B As per Rev B 06-05-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1031C3W Nutplate		Purchased	No			100	Each	55.0000	8	8			
<div> <div>Location</div> <div>ST297</div> <div>106574</div> <div>107139</div> </div> <div> <div>Loc Qty</div> <div>55</div> <div>7</div> <div>48</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3475-3 Tube		Manufactured	No			100	Each	0.0000	1	1			
<div> <div>Location</div> <div></div> <div></div> <div></div> </div> <div> <div>Loc Qty</div> <div>B 65846</div> <div></div> <div></div> </div> <div> <div>Loc Code</div> <div>③</div> <div></div> <div></div> </div>													
D3475-1 Outlet Adapter Plate		Manufactured	No			100	Each	3.0000	1	1			
<div> <div>Location</div> <div>ST</div> <div>62919</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

SA 11/01/20

24

SA 11/01/20

SA 11/01/20

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

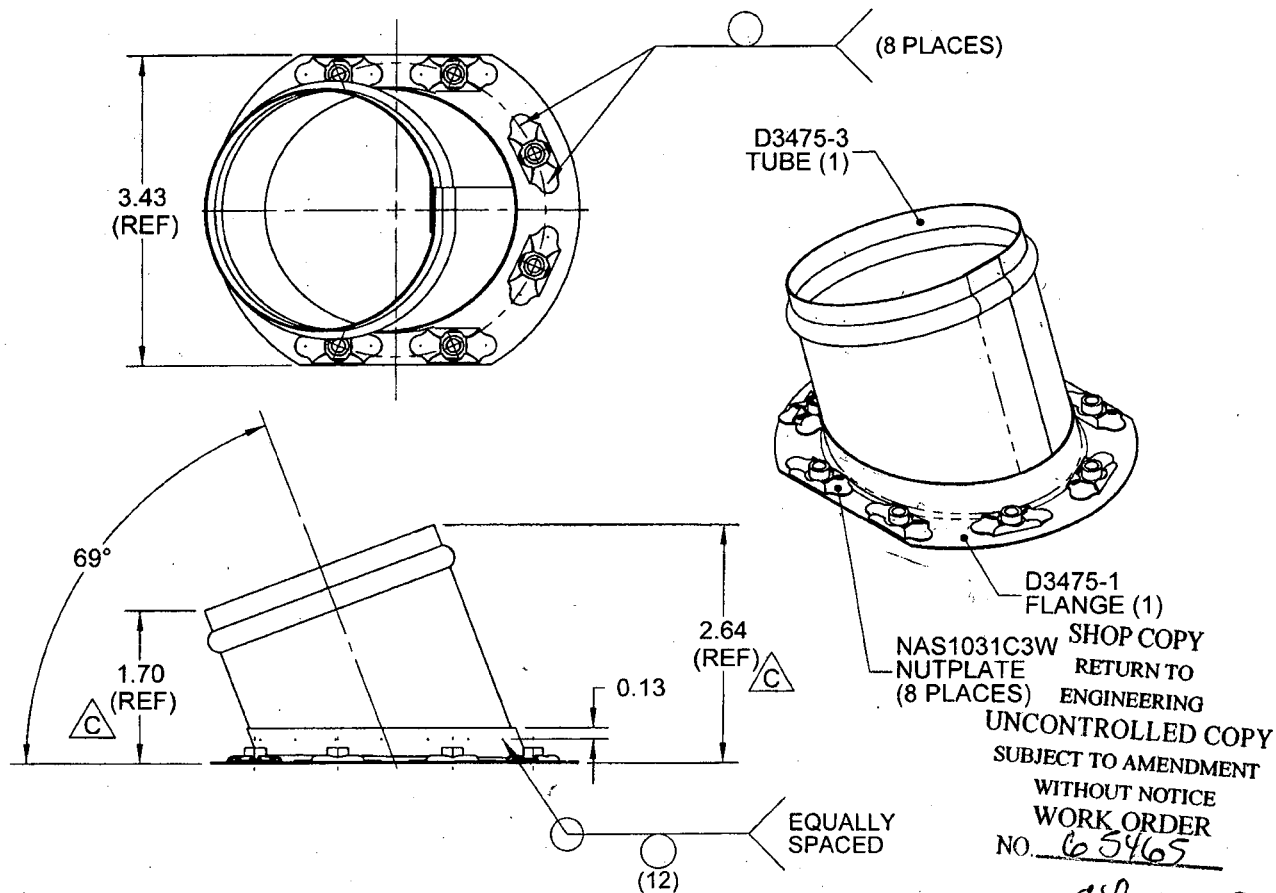
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN b	DRAWN BY b	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R4	APPROVED H	DRAWING NO. D3475	REV. C SHEET 1 OF 7
DATE 08.12.19		TITLE DUMP OUTLET	SCALE 1:2
A	06.01.24	NEW ISSUE	
B	06.05.16	REDESIGN D3475-1F/-5/-7S/-7; ADD D3475-9	
C	08.12.19	CORRECT DIMS PER D3475-3F; REMOVE Ø0.191 HOLES ON D3475-7; MATL SPEC WAS MIL-S-5019	

**D3475-041 DUMP OUTLET****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) IDENTIFY WITH DART P/N D3475-041 USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

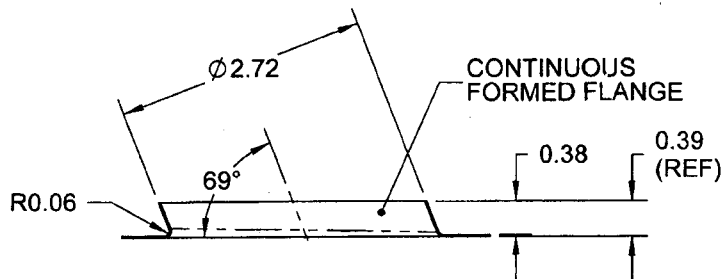
QTY -041	P/N	DESCRIPTION
X	D3475-041	DUMP OUTLET
1	D3475-1	FLANGE
1	D3475-3	TUBE
8	NAS1031C3W	NUTPLATE

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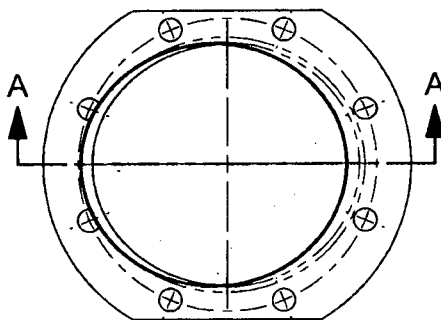
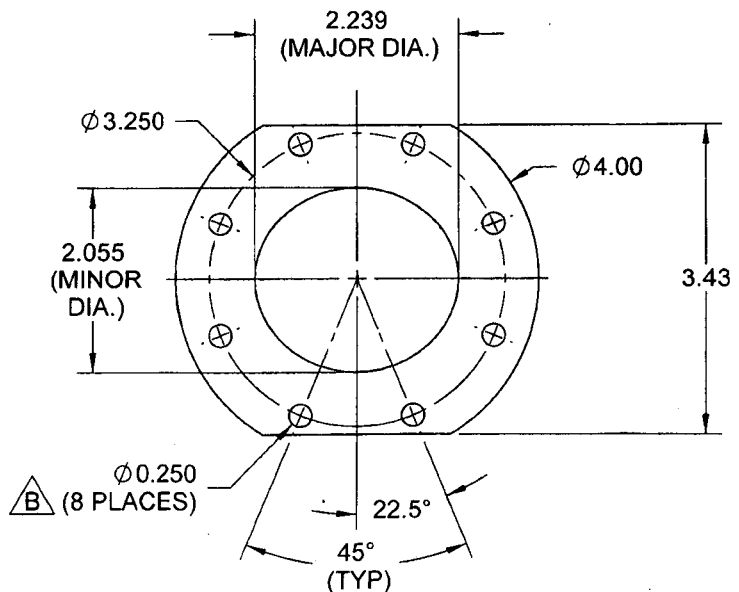
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CHECKED <i>RH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3475	REV. C SHEET 2 OF 7
DATE 08.12.19		TITLE DUMP OUTLET	SCALE 1:2

RELEASED
9/11/30 MW**SECTION A-A**

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**D3475-1 OUTLET
ADAPTER PLATE****D3475-1F FLAT PATTERN****NOTES:**

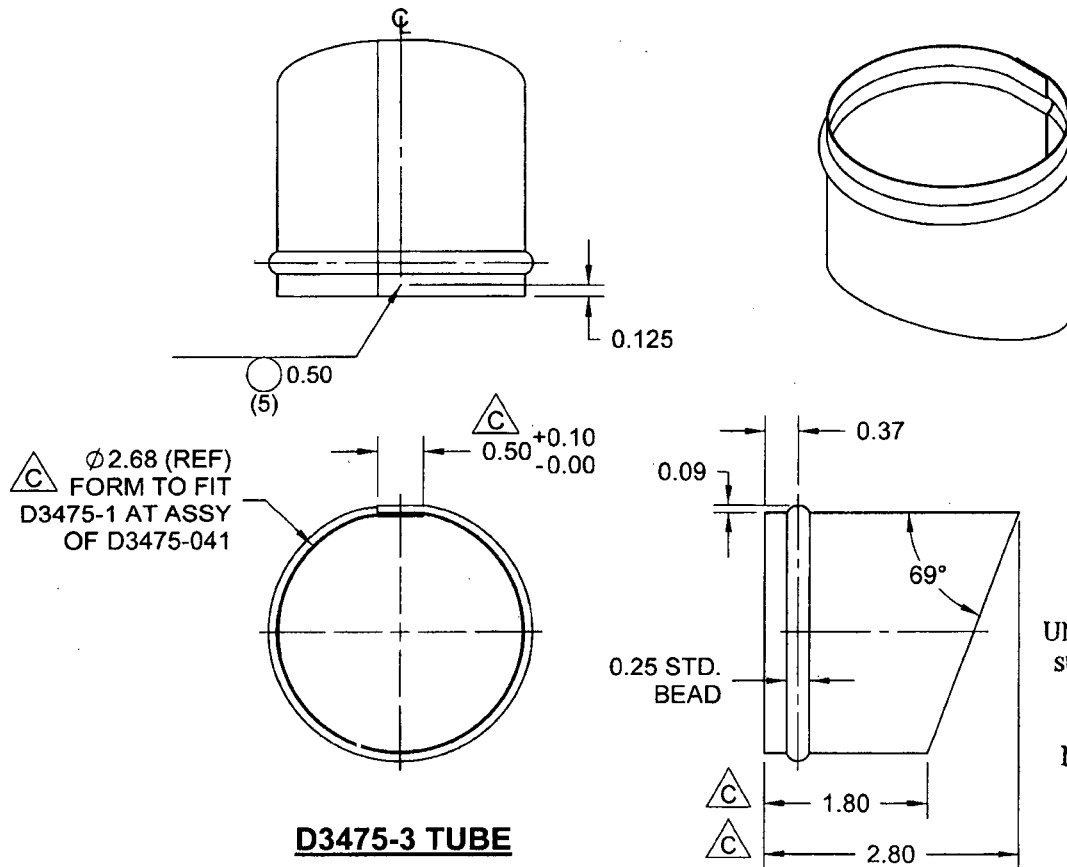
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH 
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 08.12.19		TITLE DUMP OUTLET	SCALE 1:2

RELEASED
09/01/2019

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D3475-3F TUBE FLAT PATTERN**NOTES:**

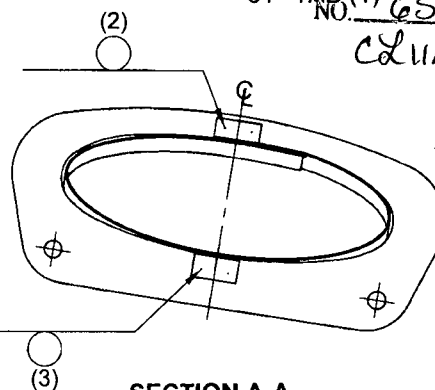
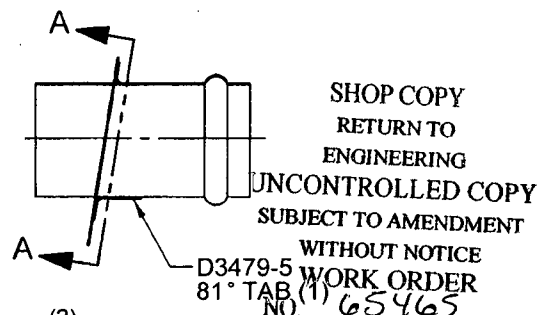
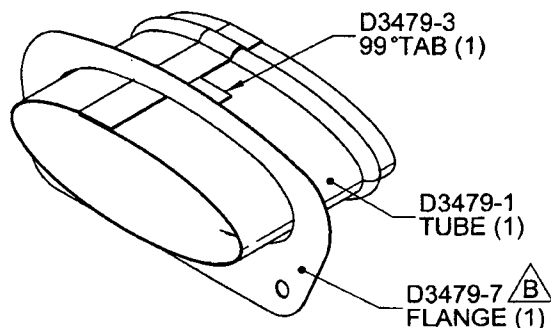
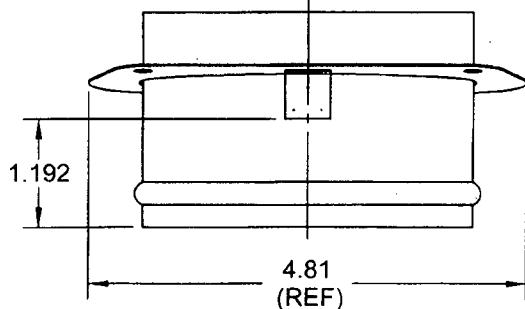
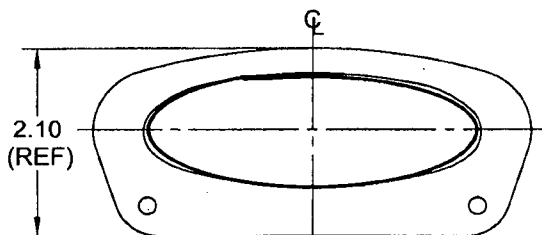
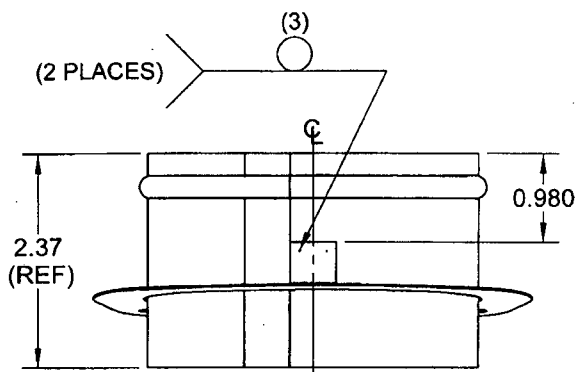
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle C$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	
B	08.12.19	CORRECT TYPO ON SHT1; ADD TOL ON SHT2; MATL SPEC WAS MIL-S-5019	

RELEASED
[Stamp]**SECTION A-A****D3479-041 INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

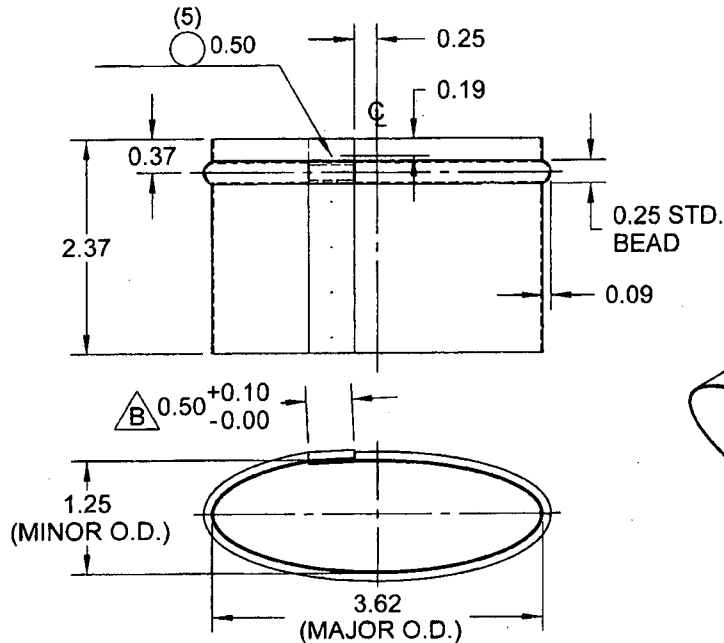
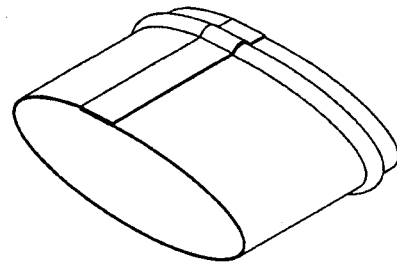
QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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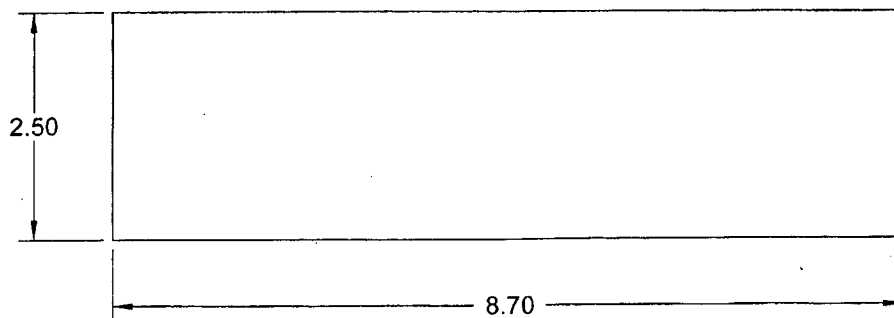
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 2 OF 4
DATE 08.12.19	TITLE INLET ADAPTER	SCALE 1:2	

RELEASED
09/01/2019**D3479-1 TUBE**

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**D3479-1F FLAT PATTERN****NOTES:**

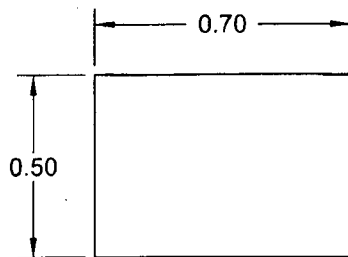
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH ΔB
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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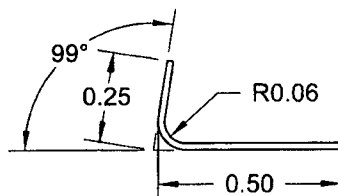
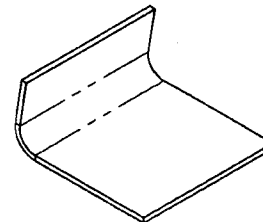
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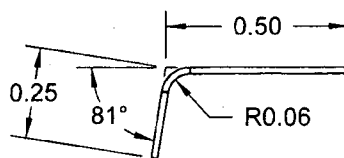
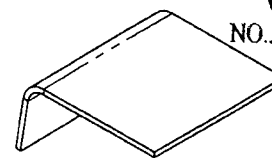
DESIGN b	DRAWN BY b	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED pt	APPROVED #	DRAWING NO. D3479	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE ADAPTER INLET	SCALE 2:1

RELEASED
09/01/30 MP**D3479-3F FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)

**D3479-3 99 DEGREE TAB**
(MAKE FROM D3479-3F FLAT PATTERN)

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**D3479-5 81 DEGREE TAB**
(MAKE FROM D3479-3F FLAT PATTERN)**NOTES:**

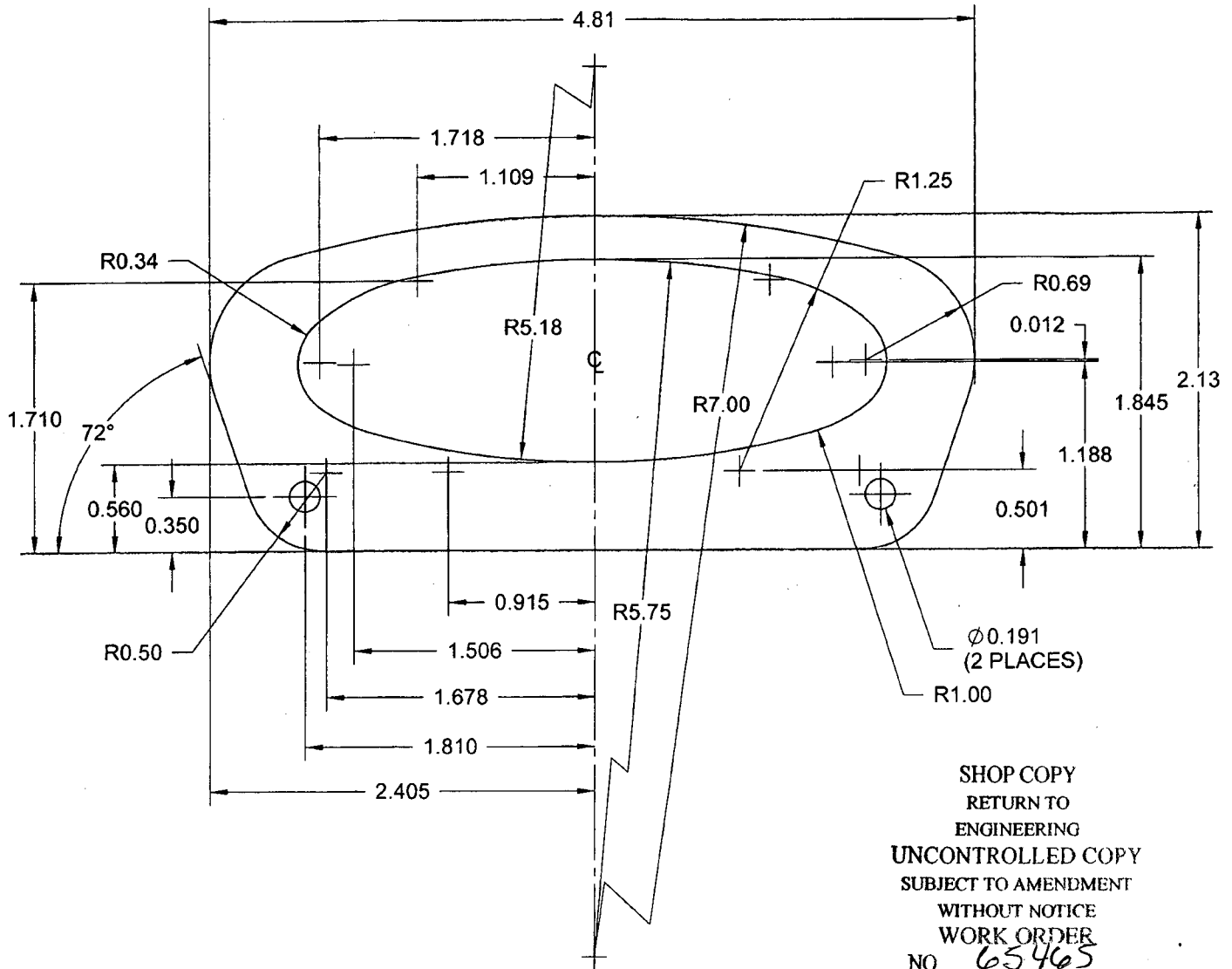
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. B SHEET 4 OF 4
DATE 08.12.19		TITLE ADAPTER INLET	SCALE 1:1

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WORK ORDER
NO. 65465

D3479-7 FLANGE PLATE**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 89

EMPLOYEE: Marc Gregory

PART NUMBER: D 3475-041

JOB NUMBER: B 65465

MATERIAL TYPE: 304

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>/</u>]	[]
PENETRATION:	[<u>/</u>]	[]
PULL STRENGTH:	[<u>/</u>]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 11/21/31

QUALIFIER: SB